

Work Order ID 134239

Tuesday, July 07, 2015 4:08:35 PM

647.4719
B134239
REV. N/C

134239

Page 1

Item ID: 647.4719

Revision ID:

Item Name: Clip Fwd

Start Date: 7/7/2015 Start Qty: 30.00

Required Date: 7/10/2015 Req'd Qty: 30.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 15-8-7

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.4700	N/C								

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

0.00

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.01

w/o costed #91282 MF 15-8-10

Work Order ID 134239

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Page 2

Item ID: 647.4719

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clip Fwd

Start Date: 7/7/2015 Start Qty: 30.00

30

Cust Item ID:

Required Date: 7/10/2015 Req'd Qty: 30.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.01

Quality Control

See w/ 9/12/82
DAS 9-89
150-27

140

Bend as per dwg

0.00

140

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

30

JUL 07 2015

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.01

Quality Control

30

DAS
38
9-89

JUL 08 2015

Work Order ID 134239

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Item ID: 647.4719

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip Fwd

Start Date: 7/7/2015 Start Qty: 30.00

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Cust Item ID:

Required Date: 7/10/2015 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

Outsource process-Anodize per QSI017 4.1.10.1

0.00

160

Outsource4

Memo

90.00

Outsource process - Anodize

Issue P/O to ATG : 29092

1- Black Anodize as per Dwg 647.4700

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Comformity is required

CL JUL 10 2015 30

170

Receive & Inspect for Damage & Mat'l Certs

0.00

170

Packaging

Memo

0.01

Packaging

30x 8015-07-22

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.01

Quality Control

30 DAS
38
9-89

AUG 05 2015

Tuesday, July 07, 2015 4:08:35 PM

134239

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Clip Fwd

Start Date: 7/7/2015 **Start Qty:** 30.00

30

Cust Item ID:

Required Date: 7/10/2015 **Req'd Qty:** 30.00

30

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

210

Identify as per dwg & Stock Location: CCK112 0.00

0.00

210

0.01

Packaging

Memo

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

30 DA3
27
9-30

JA

AUG 05 2016

220

QC21- Final Inspection - Work Order Release	0.00
---	------

0.00

220

0.05

QC

Memo

Quality Control

MC

AUG 10 2015

MS-87

Picklist Print

Tuesday, July 07, 2015 4:08:34 PM

Page 1

Work Order ID: 134239

134239

Parent Item: 647.4719

647 4719

Parent Item Name: Clip Fwd

Start Date: 7/7/2015

Required Date: 7/10/2015

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 12.09.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No		110	sf	110.8882	0.044	2			
M2024T3S 040									**				
2024-T3 .040 sheet													

Location

MAT022

m130497

m132359

Loc Qty

110.8882

14.8882

96

Loc Code

SEE Q1282
M25-8-7

Work Order ID 91282

91282

October-05-12 9:22:19 AM

Item ID: 647.4719

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Clip Fwd

Stop *NS2*

Start Date: 10/04/12 Start Qty: 30.00

30

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: ML3

Date: 12-10-05 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.4700

N/C

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: N/C

Prog Rev: N/C

2-Deburr if necessary

30 0 Im 12-10-14

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

30 0 Im 12-10-14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data ☐												
Equip/Tooling ☐												
Operator ☐												
Material ☐												
Setup ☐												
Other ☐												
Process ☐												
Supplier ☐												
Training ☐												
Unapproved ☐												
FAULT CATEGORY												
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	

Work Order ID 91282

91282

Page 2

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Item ID: 647.4719

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clip Fwd

Stop ***NS2***

Start Date: 10/04/12 Start Qty: 30.00

30

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>Smb 12/15</i>		<i>30 cont</i>			
140 *140* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											

FAULT CATEGORY										
Landing Gear			General							
☐ Bending	☐ Centre Not Concentric to O/S	☐ Cracks	☐ Crushed/Crimped	☐ Cuffs	☐ Heat Treat	☐ Inspection Strip in Tube	☐ Ripples in Bend	☐ Torque Waves in Extrusion	☐ Turning Sequence	☐ Wave/Twist in Tube
☐ Bend	☐ BOM/Route	☐ Broken/Damaged	☐ Burrs	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Drill Holes	☐ Drawing	☐ Finish	☐ Folio
☐ Grain	☐ Hardware	☐ Inspection Incomplete	☐ Instructions Incomplete/Unclear	☐ Maintenance	☐ Mislabeled	☐ Misread	☐ Offset	☐ Out of Calibration	☐ Out of Sequence	☐ Outside Dimensions
☐ Ovalized	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Positioned Wrong	☐ Power Loss/Surge	☐ Pressure/Forced	☐ Temperature/Cure	☐ Weld	☐ Wrong Stock Pulled
							☐ Other			

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/04/12 **Start Qty:** 30.00 ***30***

Cust Item ID:

Required Date: 10/31/12 **Req'd Qty:** 30.00 ***30***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Outsource process-Anodize per QSI017 4.1.10.1

0.00

160

Outsource4

Memo

0.00

Outsource process - Anodize

HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

Receive & Inspect for Damage & Mat'l Certs

0.00

170

Packaging

Memo

0.00

Packaging

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube ☐</td> <td style="width:25%;">Crosstube ☐</td> <td style="width:25%;">Water Jet ☐</td> <td style="width:25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐																								
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																								
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																								
Large Fab ☐	Composite ☐	Supplier ☐																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data ☐																											
Equip/Tooling ☐																											
Operator ☐																											
Material ☐																											
Setup ☐																											
Other ☐																											
Process ☐																											
Supplier ☐																											
Training ☐																											
Unapproved ☐																											

FAULT CATEGORY										
Landing Gear			General							
☐ Bending	☐ Centre Not Concentric to O/S	☐ Cracks	☐ Crushed/Crimped	☐ Cuffs	☐ Heat Treat	☐ Inspection Strip in Tube	☐ Ripples in Bend	☐ Torque Waves in Extrusion	☐ Turning Sequence	☐ Wave/Twist in Tube
☐ Bend	☐ BOM/Route	☐ Broken/Damaged	☐ Burrs	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Drill Holes	☐ Drawing	☐ Finish	☐ Folio
☐ Grain	☐ Hardware	☐ Inspection Incomplete	☐ Instructions Incomplete/Unclear	☐ Maintenance	☐ Mislabeled	☐ Misread	☐ Offset	☐ Out of Calibration	☐ Out of Sequence	☐ Outside Dimensions
☐ Ovalized	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Positioned Wrong	☐ Power Loss/Surge	☐ Pressure/Forced	☐ Temperature/Cure	☐ Weld	☐ Wrong Stock Pulled
							☐ Other			

Work Order ID 91282

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91282

Page 4

Item ID: 647.4719

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Clip Fwd

Stop ***NS2***

Start Date: 10/04/12 Start Qty: 30.00

30

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
190									
SprayPaint	Memo	0.00							
Spray Painting	PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)								
	CARDINAL 4860-50 PRIMER BATCH: _____								
200	QC14- Inspect Spray Paint	0.00							
200									
QC	Memo	0.00							
Quality Control									
210	Identify as per dwg & Stock Location: _____	0.00							
210									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											

FAULT CATEGORY										
Landing Gear			General							
☐ Bending	☐ Centre Not Concentric to O/S	☐ Cracks	☐ Crushed/Crimped	☐ Cuffs	☐ Heat Treat	☐ Inspection Strip in Tube	☐ Ripples in Bend	☐ Torque Waves in Extrusion	☐ Turning Sequence	☐ Wave/Twist in Tube
☐ Bend	☐ BOM/Route	☐ Broken/Damaged	☐ Burrs	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Drill Holes	☐ Drawing	☐ Finish	☐ Folio
☐ Grain	☐ Hardware	☐ Inspection Incomplete	☐ Instructions Incomplete/Unclear	☐ Maintenance	☐ Mislabeled	☐ Misread	☐ Offset	☐ Out of Calibration	☐ Out of Sequence	☐ Outside Dimensions
☐ Ovalized	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Positioned Wrong	☐ Power Loss/Surge	☐ Pressure/Forced	☐ Temperature/Cure	☐ Weld	☐ Wrong Stock Pulled
							☐ Other			

Work Order ID 91282

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91282

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Item ID: 647.4719

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip Fwd

Start Date: 10/04/12 Start Qty: 30.00

30

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Page 1

Work Order ID: 91282

Parent Item: 647.4719

Parent Item Name: Clip Fwd

Start Date: 10/04/12

Required Date: 10/31/12

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 12.09.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040		Purchased	No			110	sf	237.0112	0.044	13894737 1.4			
2024-T3 .040 sheet													Jun 12-10-14

Location	Loc Qty	Loc Code
MAT022	237.0111626	
120605	32.9127416	
121197	32.498421	
122136	23.7	
123217	147.9	

~~123217~~

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube ☐</td> <td style="width: 33%;">Crosstube ☐</td> <td style="width: 33%;">Water Jet ☐</td> <td style="width: 33%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐																								
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																								
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																								
Large Fab ☐	Composite ☐	Supplier ☐																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data ☐																											
Equip/Tooling ☐																											
Operator ☐																											
Material ☐																											
Setup ☐																											
Other ☐																											
Process ☐																											
Supplier ☐																											
Training ☐																											
Unapproved ☐																											

FAULT CATEGORY										
Landing Gear			General							
☐ Bending	☐ Centre Not Concentric to O/S	☐ Cracks	☐ Crushed/Crimped	☐ Cuffs	☐ Heat Treat	☐ Inspection Strip in Tube	☐ Ripples in Bend	☐ Torque Waves in Extrusion	☐ Turning Sequence	☐ Wave/Twist in Tube
☐ Bend	☐ BOM/Route	☐ Broken/Damaged	☐ Burrs	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Drill Holes	☐ Drawing	☐ Finish	☐ Folio
☐ Grain	☐ Hardware	☐ Inspection Incomplete	☐ Instructions Incomplete/Unclear	☐ Maintenance	☐ Mislabeled	☐ Misread	☐ Offset	☐ Out of Calibration	☐ Out of Sequence	☐ Outside Dimensions
☐ Ovalized	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Positioned Wrong	☐ Power Loss/Surge	☐ Pressure/Forced	☐ Temperature/Cure	☐ Weld	☐ Wrong Stock Pulled
							☐ Other			

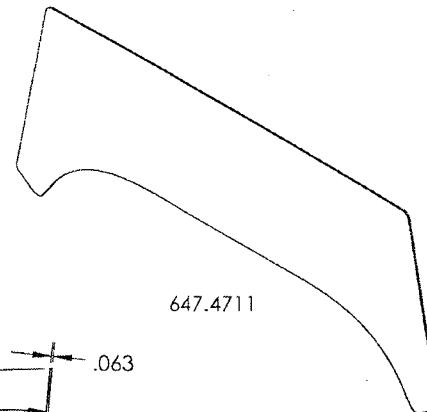
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NOTES: UNLESS OTHERWISE SPECIFIED

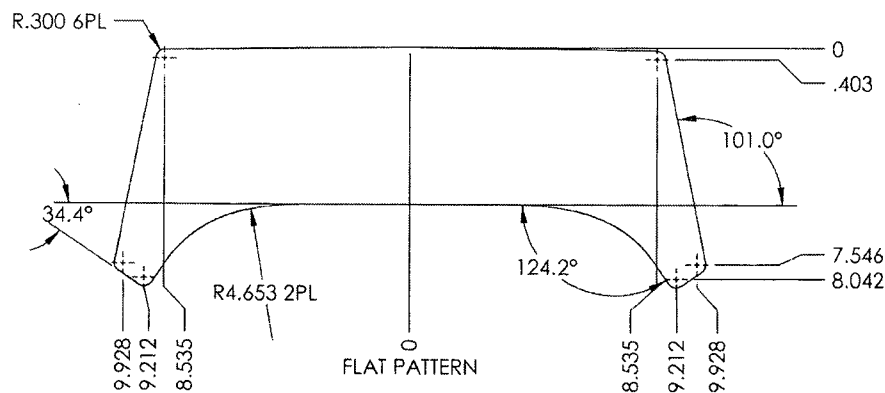
1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

SHOULDER
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 91282 MJS
12-10-05



647.4711



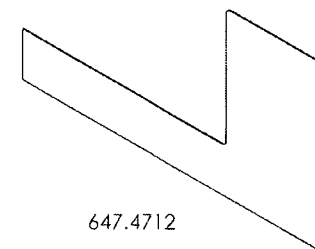
QTY	PART #	DESCRIPTION	MAT'L	SPEC.
1	647.4719	CLIP FWD	△	△
1	647.4718	CLIP AFT RH	△	△
1	647.4717	CLIP AFT LH	△	△
1	647.4716	SPACER	△	△
1	647.4715	CLIP RH	△	△
1	647.4714	CLIP LH	△	△
1	647.4713	BRACKET	△	△
1	647.4712	DOUBLER	△	△
1	647.4711	DOUBLER	△	△
QTY	PART #	DESCRIPTION	MAT'L	SPEC.
1	647.2600	CLIP FWD	△	△
1	647.2600	CLIP AFT RH	△	△
1	647.2600	CLIP AFT LH	△	△
1	647.2600	SPACER	△	△
1	647.2600	CLIP RH	△	△
1	647.2600	CLIP LH	△	△
1	647.2600	BRACKET	△	△
1	647.2600	DOUBLER	△	△
1	647.2600	DOUBLER	△	△

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300
SHEETMETAL
SCALE NONE
SHEET 1 OF 7

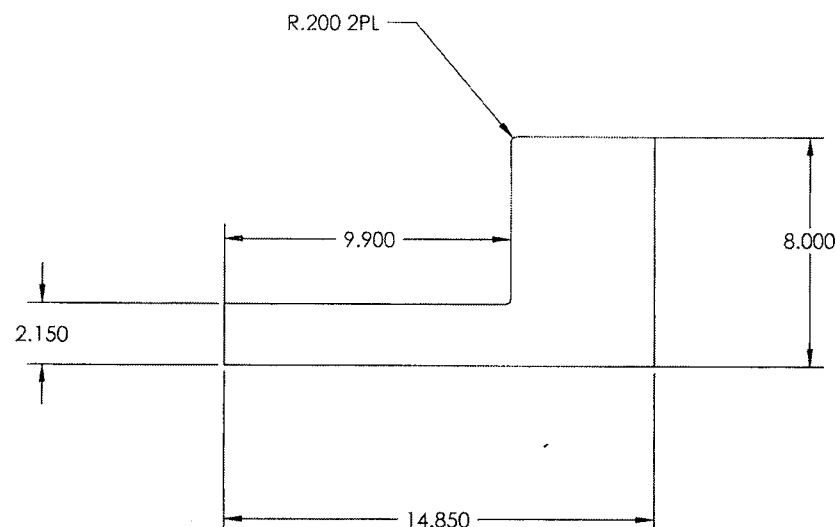
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REV	DESCRIPTION	DATE	APPROVED

91282



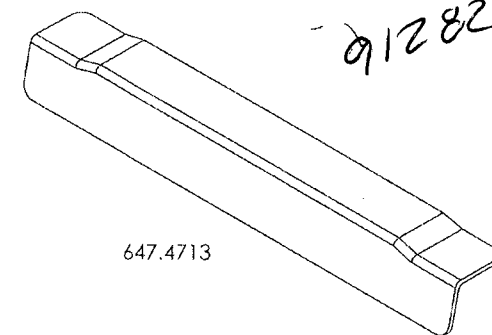
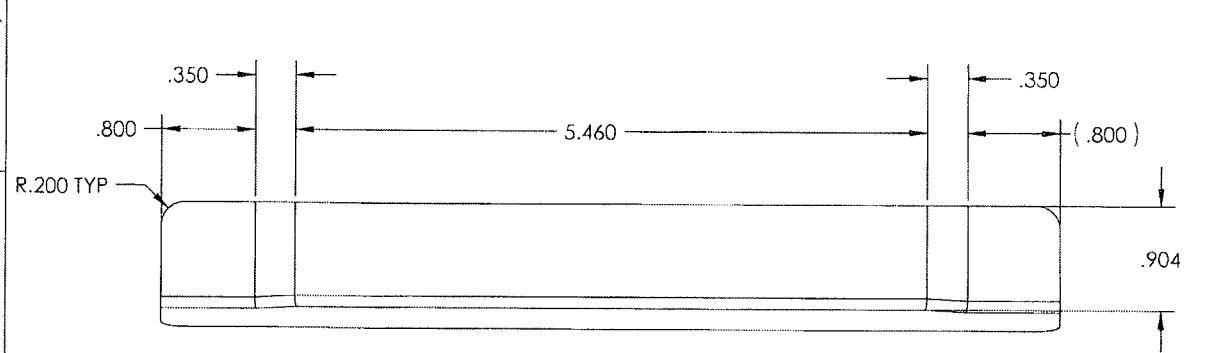
647.4712



ORIGINAL DATE 2000-04-10	7/2-3/00	APICAL INDUSTRIES	
DRAWN BY A. CUNHA	CHECKED BY D. BAYLER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAY	DATE 05/12/07	SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.002 ANGLES ±.5°		SIZE B	SCALE NONE
SHEET 2 OF 7		REV. N/C	

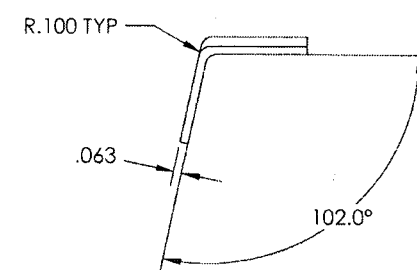
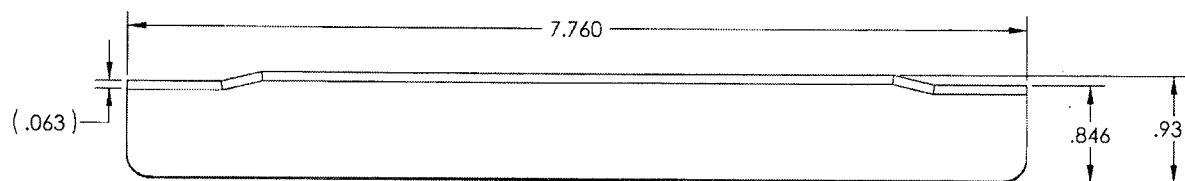
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



01282

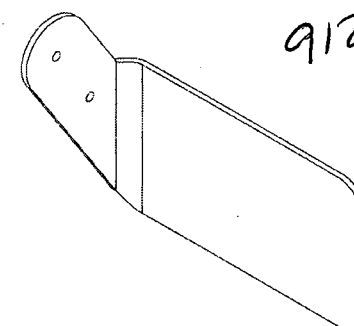
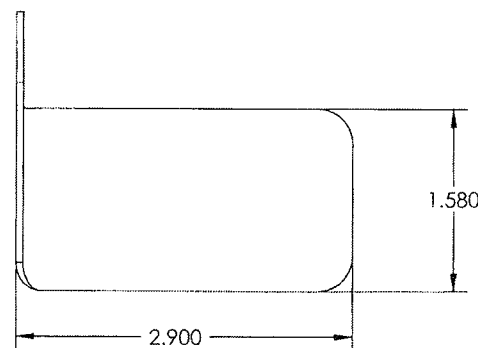
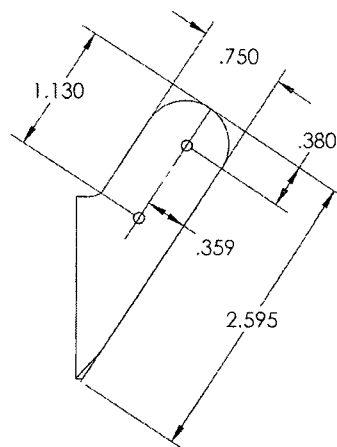
647.4713



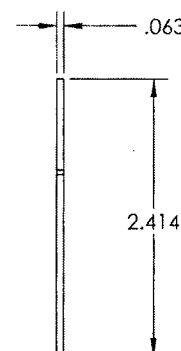
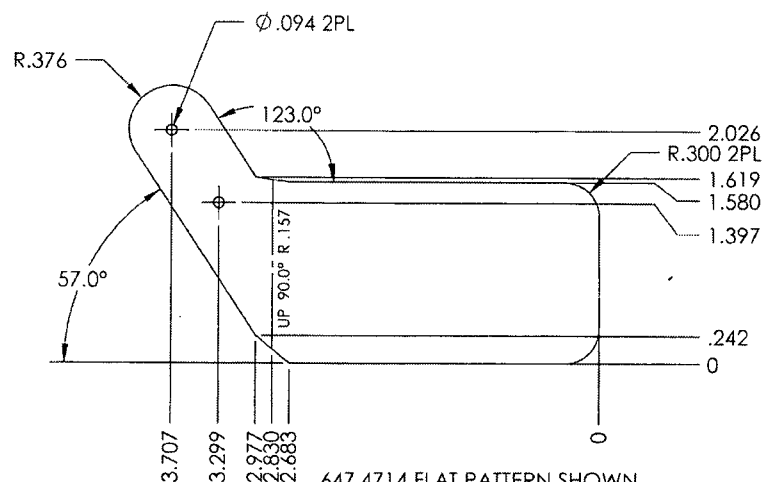
ORIGINAL DATE: 7/20/2011 DRAWN BY: A. CUNY CHECKED BY: J. BARTER DRAWING APPROVAL: 7/20/2011 CONTRACT NO: 1		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DECIMALS ARE .001 3 PLACE DECIMALS .001 4 DIGITS .0001		SHEETMETAL SCALE: NONE	REV. NO: 647.4700 N/C SHEET 3 OF 7

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REV	DESCRIPTION	DATE	APPROVED



647.4714 SHOWN
647.4715 OPPOSITE



647.4714 FLAT PATTERN SHOWN
647.4715 BEND DOWN

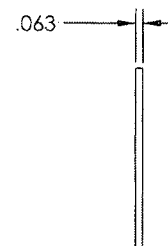
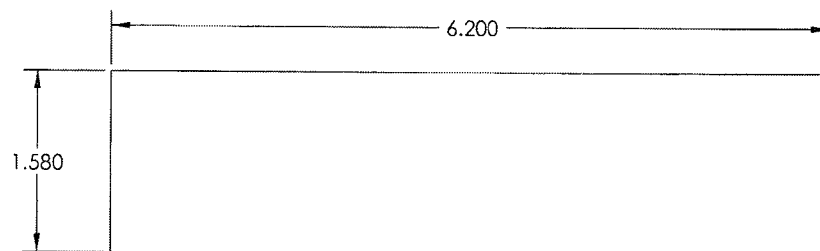
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
SHEETMETAL	
REV	DATE
8	07/18/16
SCALE	NONE
DWG. NO.	647.4700
REV.	N/C
SHEET 4 OF 7	

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISED		DATE		APPROVED	
REV	DESCRIPTION				

91282

647.4716

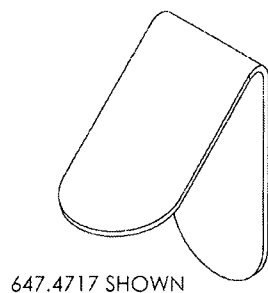


ORIGINAL DATE 10/13/08		APICAL INDUSTRIES	
DRAWN BY A. QUINN		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 1760/724-5300	
DRAWING APPROVAL 10/13/08		SHEETMETAL	
CONTRACT 110			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 ANGLES ±.5°		SET B SCALE CODE 07M26 DWG NO 647.4700 SCALE NONE	PLY N/C SHEET 5 OF 7

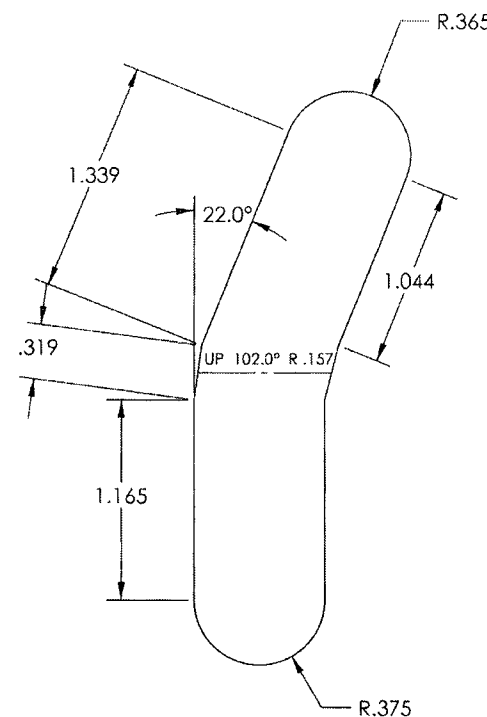
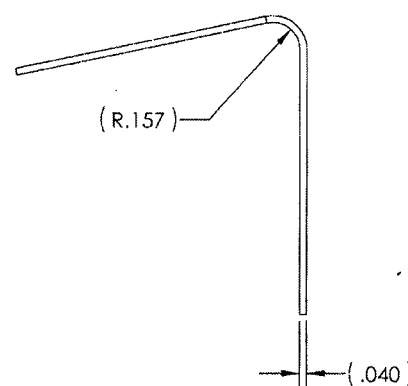
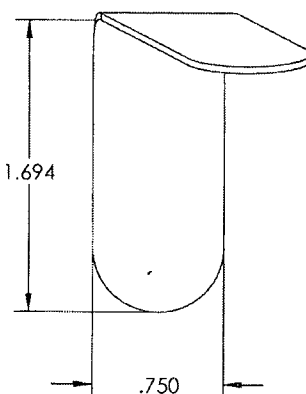
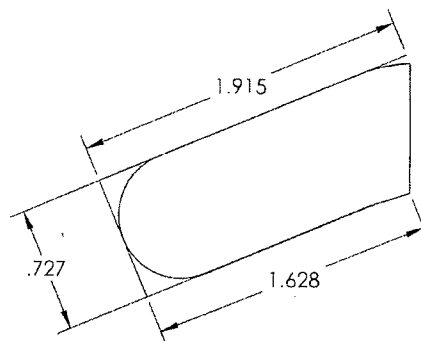
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

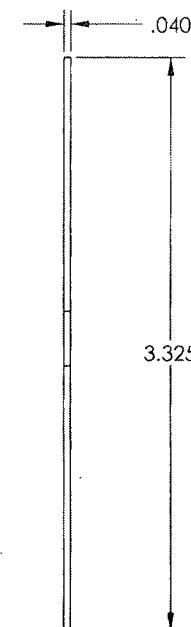
91282



647.4717 SHOWN



647.4717 FLAT PATTERN SHOWN
647.4718 BEND DOWN

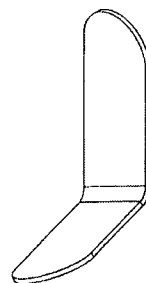
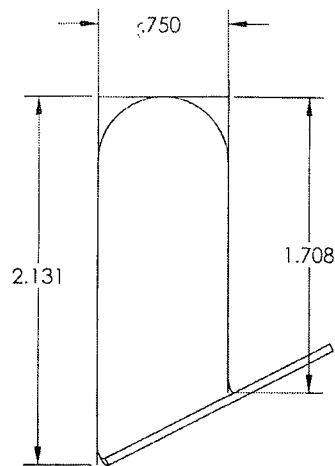


GENERAL DATA		APICAL INDUSTRIES	
DATE	07/13/09	2608 TEMPLE HEIGHTS DR.	
DRAWN BY	TOUCHER	OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED	D. BERRY	SHEETMETAL	
DRAWING APPROVAL			
BY			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE			
3 PLACE DECIMALS ± .01			
3 PLACE DECIMALS ± .005			
ANGLES ± .5°			
SRI	CA DE CODE	ENG. NO.	REV.
B	07M26	647.4700	N/C
SCALE: NONE		SHEET 6 OF 7	

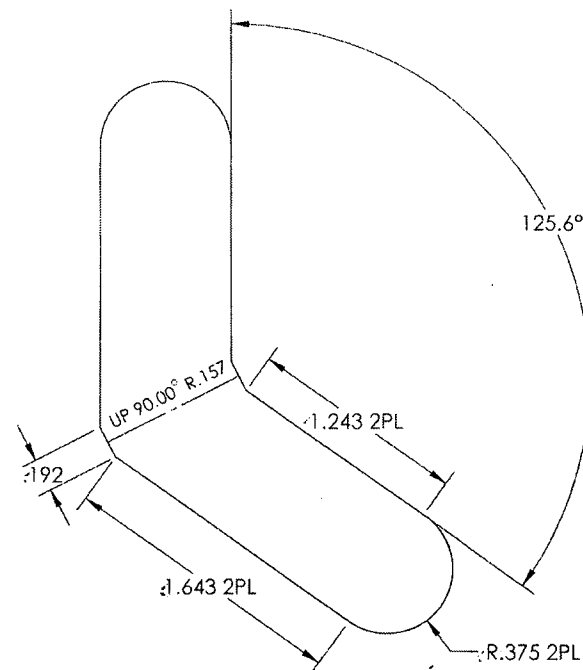
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REV	DESCRIPTION	DATE	APPROVED

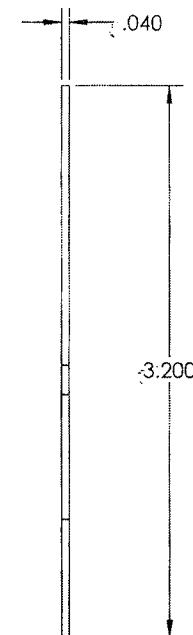
91282



647.4719



647.4719 FLAT PATTERN



ORIGINAL DATE 10/11/03 DRAWN BY J. QUINN CHECKED D. BARNER DRAWING APPROVAL P. BLAVO HELD BY CORRECTION NO.		APICAL INDUSTRIES 2600 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET 2 OF 7 SCALE NONE	REV N/C 647.4700



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 63830

Date: 22-Jul-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	Line:
30 ea	Part: 647.4719 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N MINIMUM RUN Job: 20150559		
Certificate of Conformance			
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.			
ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY			
DATE: <u>22/7/15</u>			
CERTIFIED SIGNATURE: <u>[Signature]</u>			
RECEIVER SIGNATURE: <u>[Signature]</u> 15-07-22			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29092**

Purchase Order Date 7/10/2015

PO Print Date 7/22/2015

Page Number 1 of 2

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	134239	647.4719 clip fwd	7/17/2015 Yes 7/17/2015		30.00 ✓	\$12.00	\$360.00
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N							

Line Total: \$360.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	7/17/2015 No 7/17/2015		1.00 ✓	\$0.00	\$0.00
Procurement Quality Clauses A004 FAA-PMA /TSO A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A024 PROCESS CERTIFICATIONS A025 CERTIFICATE OF CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

8/15-07-22

Note:

7/22/2015